

17-4 H900 1.00
Work Order ID 79300

79300

Page 1

Item ID: D3688-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: STUD

Start Date: 24/01/2012 Start Qty: 5.00

5

Cust Item ID:

Required Date: 07/02/2012 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan: M.L.S

Date: 12/01/24

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3688	Rev C								

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

DO NOT USE CHOP SAW

Cut blank 11.673" long

SL 12/3/18

110

0.00

110

DOOSAN LATHE

Doosan

Memo

0.00

Doosan Lathe

1-Turn as per Folio FA718 Rev: AA & Dwg D3688 Rev: C 2-Deburr
per dwg D3688

3-Check .625" bore with DT9530 GO/NO GO Gauge

SL 12/3/19

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

SL 12/3/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 79300

79300

Page 2

January-24-12 1:55:31 PM

Item ID: D3688-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: STUD
 Start Date: 24/01/2012 Start Qty: 5.00 *5* Cust Item ID:
 Required Date: 07/02/2012 Req'd Qty: 5.00 *5* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC8- Inspect parts - second check	0.00				5	0		BB 12/03/12
170									
QC	Memo	0.00							
Quality Control	100% CHECK,CHECK ALL DIMENSIONS AND THREAD FIT								
180	PURCHASING	0.00							
180									
Purchasing	Memo	0.00							
Purchasing	Issue P/O: 16555 LPI Per ASTM 1417 LEVEL								
	2Certificate of conformaty is required								
190	Receive & Inspect for Damage & Mat'l Certs	0.00							
190									
Packaging	Memo	0.00							
Packaging	Ensure certificate of conformity is attached								

CL 12/03/12 5

4/2/12 6 BT

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 79300

79300

Page 3

January-24-12 1:55:31 PM

Item ID: D3688-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: STUD
 Start Date: 24/01/2012 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 07/02/2012 Req'd Qty: 5.00 ***5*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

200	QC5- Inspect part completeness to step on W/O	0.00							
200									
QC	Memo	0.00							
Quality Control									

210	Identify as per dwg & Stock Location: ST GA	0.00							
210									
Packaging	Memo	0.00							
Packaging									

220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	0.00							
Quality Control									

12/4/2 **20**
 12-03-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

-Picklist Print

January-24-12 1:55:35 PM

Page 1

Work Order ID: 79300

79300

Parent Item: D3688-1

D3688-1

Parent Item Name: STUD

Start Date: 24/01/2012

Required Date: 07/02/2012

Start Qty: 5.00

Required Qty: 5.00

Comments:

IPP Rev:A New Issue 08-01-29 JLM Verified By:EC
IPP Rev:B Material Change 09-01-07 JLM Verified By:EC
IPP Rev:C Added note on Step 2 09-01-26 JLM Verified By:EC
IPP REV:D 10.07.06 revo step 130-160 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M174PH-H900R1.000		Purchased	No			100	f	21.2000	1.087	5.721053			
M174PH-H900R1 000									**	SA 12/31/18			
17-4SS H900 ROUND BAR 1.00													

Location

MAT030

117445

Loc Qty

21.2

21.2

Loc Code

120767

SA

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

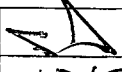

NOTE: Date & initial all entries



DART AEROSPACE LTD		Work Order:	79300
Description: Stud		Part Number:	D3688-1
Inspection Dwg: D3688	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.695	+/-0.010	.702	/		SA-9	
0.625	+0.004/-0.000	.627	/			
1.25	+0.000/-0.03	1.220	/			
118°	0.5°	118°	/			
R0.03	+/-0.030	R.03	/			
0.11 Ref	+/-0.030	.11	/			
90°	0.5°	90°	/			
Ø0.189	+0.005/-0.001	.192	/			
1.31	+/-0.030	1.31	/			
1.65	+/-0.030	1.65	/			
0.870	+0.000/-0.010	.882	/			
Ø0.659	+0.000/-0.015	.647	/			
11.573	+/-0.015	11.583	/			
2.90	+/-0.030	2.90	/			
3/4-16UNF-2A	N/A		/			
0.075 x 45°	+/-0.010 x 0.5°	.075 x 45°	/			
0.370	+0.000/-0.010	.362	/			
Ø0.189	+0.005/-0.001	.192	/			
R0.25	+/-0.030	R.25	/			
R0.50	+/-0.030	R.50	/			

Measured by: 	Audited by: 	Prototype Approval:	N/A
Date: 12/3/19	Date: 12/10/19	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.05.11	New Issue	KJ	
B	09.11.04	Dwg Rev updated	KJ 	

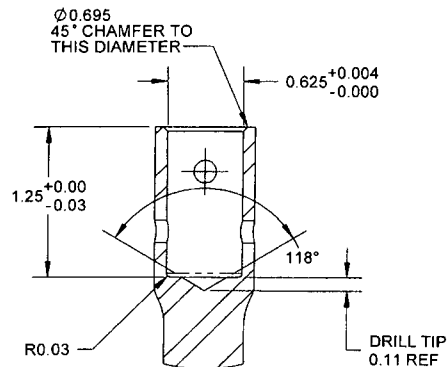
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

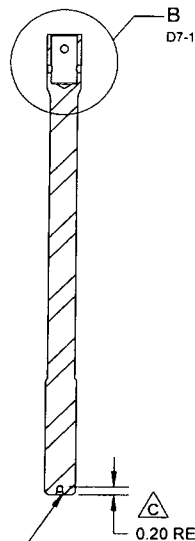
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

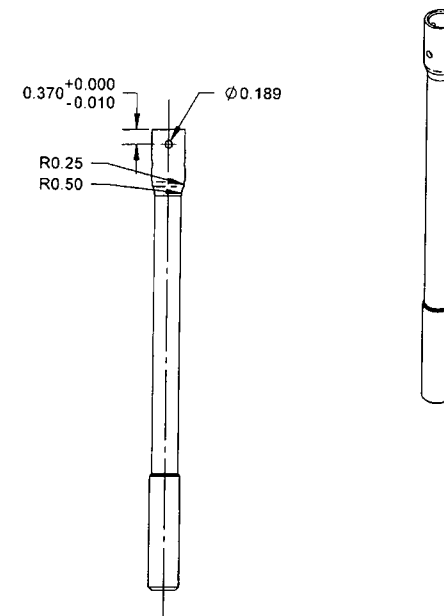
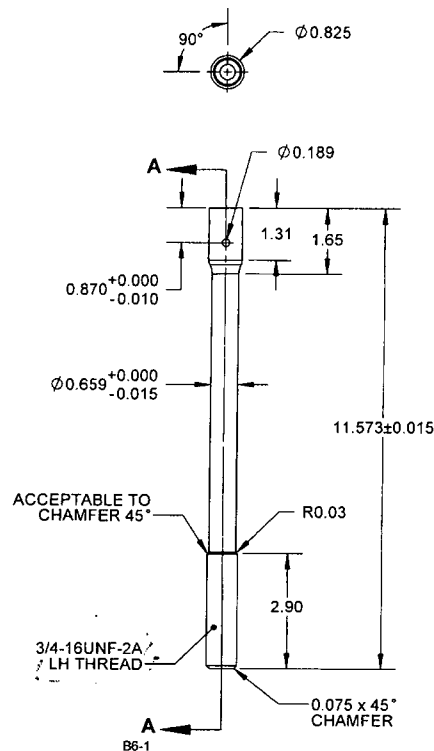
- NOTE: Date & initial all entries



DETAIL B
SCALE 3X
D6-1



SECTION A-A
D4-1



RELEASED
2009-09-22

SHOWN COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO
WITHIN 14
WORK ORDER
NO. 79300 M.C.J.
12/01/24

NOTES:

- 1) MATERIAL: 17-4PH STAINLESS STEEL ROUND BAR PER AMS 5643 H-900 CONDITION
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.24 lb
- 8) LPI PER QSI 038 4.1.1 (ASTM E1417 LEVEL 2)

D3688-1 STUD

C	0.20 WAS 0.16 (ZN B5-1, B5-2, B6-3, B5-4); CENTER DRILL #4 WAS CENTER DRILL #2 (ZN B6-1, B6-2, B6-3, B6-4); UPDATE NOTE 8 TO REF QSI (ZN A8-1, A8-2, A8-3, A8-4)	RF	09.09.09
B	CHANGE TO 17-4PH H-900 (ZN A8-1, A8-2, A8-3, A4-4); REDUCE LENGTH ON D3688-1 FROM 12.073 TO 11.573 (ZN C3-1) BASED ON PROTOTYPE INSTALL; Ø0.695 WAS Ø0.665 (ZN D8-1, D8-2, D8-3); Ø0.508 WAS Ø0.478 (ZN D8-4); REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.05.22
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3688 TITLE STUD DATE 09.09.09	
DRAWN	RF		
CHECKED	RF		
MFG. APPR.	RF		
APPROVED	RF		
DE APPR.	RF	REV. C	SHEET 1 OF 4
DATE	09.09.09	SCALE	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

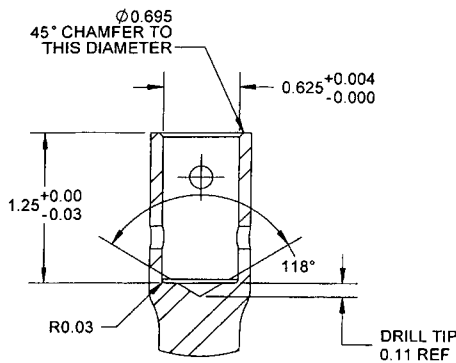
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

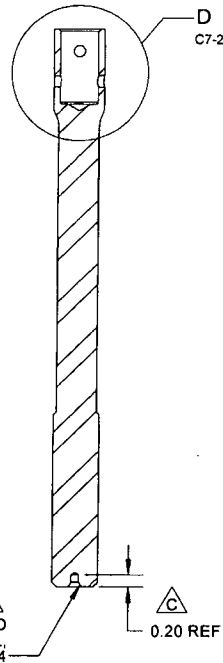
NOTE: Date & initial all entries

29300

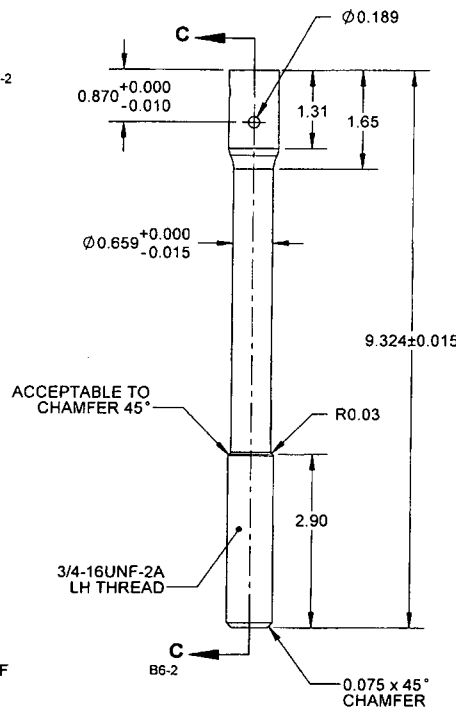
8 7 6 5 4 3 2 1



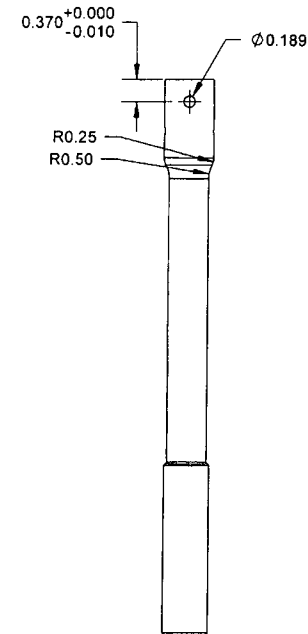
DETAIL D
SCALE 2X
D6-2



SECTION C-C
D4-2



D3688-3 STUD



RELEASED
2009-09-22
JWH

NOTES:

- 1) MATERIAL: 17-4PH STAINLESS STEEL ROUND BAR PER AMS 5643 H-900 CONDITION
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.97 lb
- 8) LPI PER QSI 038 4.1.1 (ASTM E1417 LEVEL 2)

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	QD	DRAWING NO.	REV. C
MFG. APPR.	QD	D3688	SHEET 2 OF 4
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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

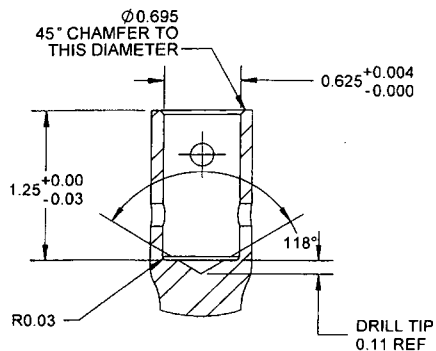
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

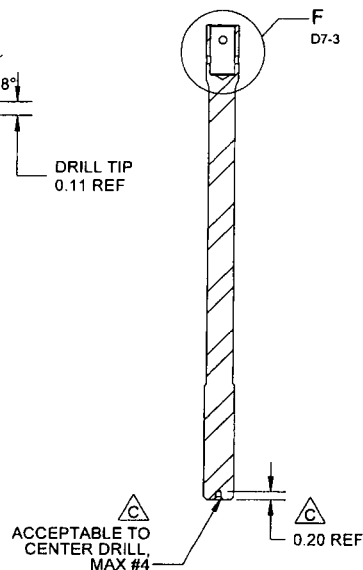
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

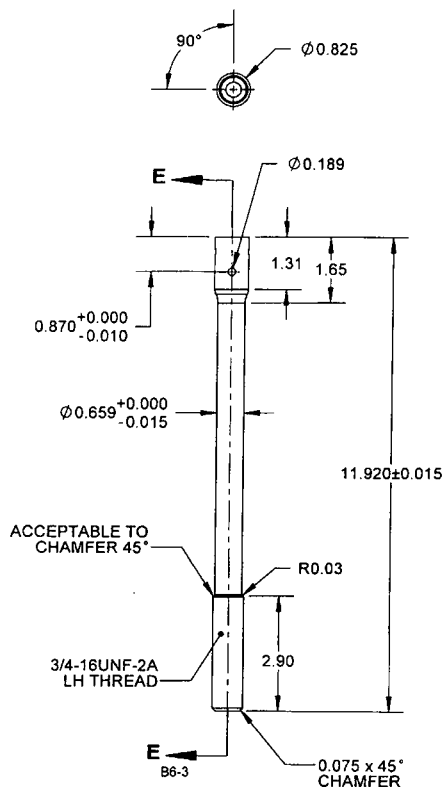
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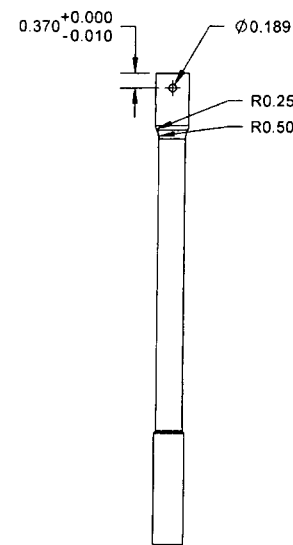
DETAIL F
SCALE 3X
D6-3



SECTION E-E
D4-3



D3688-5 STUD



NOTES:

- 1) MATERIAL: 17-4PH STAINLESS STEEL ROUND BAR PER AMS 5643 H-900 CONDITION
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.26 lb
- 8) LPI PER QSI 038 4.1.1 (ASTM E1417 LEVEL 2)

RELEASED
2009-08-22

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	GP	DRAWING NO.	REV. C
MFG. APPR.	GP	D3688	SHEET 3 OF 4
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DE APPR.	GP	STUD	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

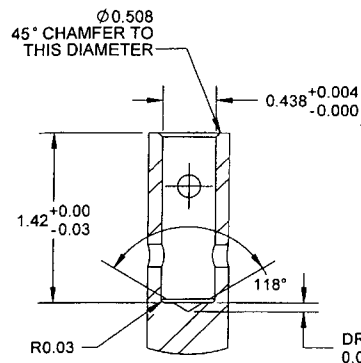
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

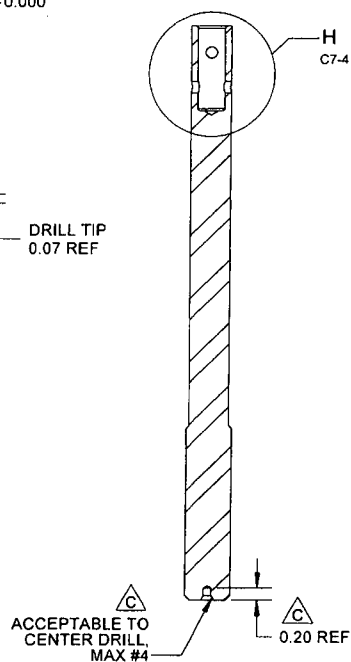
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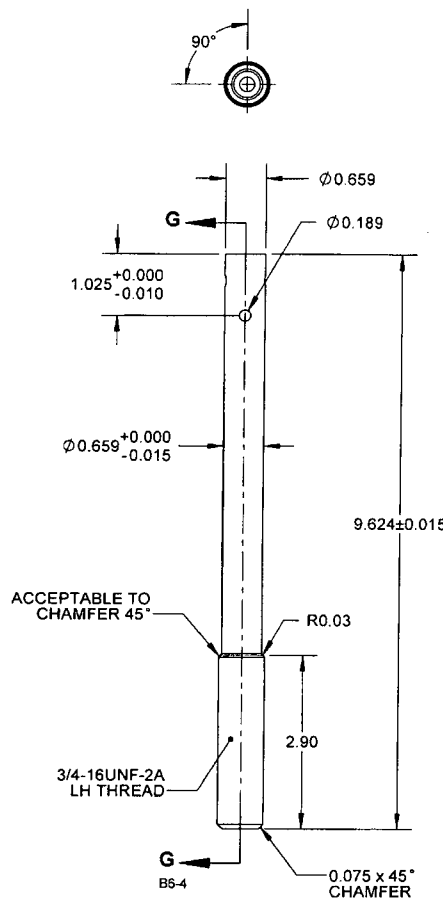
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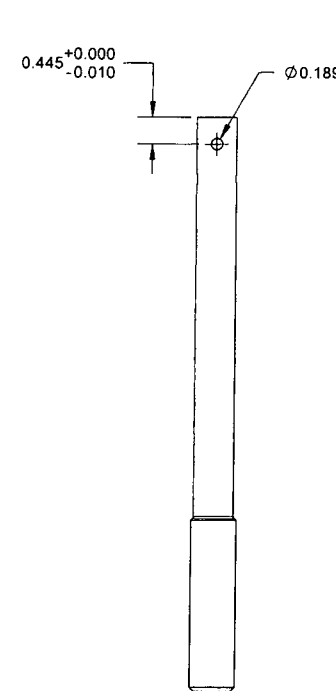
DETAIL H
SCALE 2X
D6-4



SECTION G-G
D4-4



D3688-7 STUD



RELEASED
2009-09-22

- NOTES:**
- 1) MATERIAL: 17-4PH STAINLESS STEEL ROUND BAR PER AMS 5643 H-900 CONDITION
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.97 lb
 - 8) LPI PER QSI 038 4.1.1 (ASTM E1417 LEVEL 2)

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	QD	DRAWING NO.	REV. C
MFG. APPR.	SA	D3688	SHEET 4 OF 4
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



LIQUID PENETRANT TEST REPORT

P- 12179

CLIENT	DART Aerospace	DATE	03/23/2012	PAGE	1	OF	1	
ATTENTION	LINDA LACELLE	ACUREN JOB NO.	188-12-00072	TIME	AM	<input checked="" type="checkbox"/>	PM	<input type="checkbox"/>
ADDRESS	1270 ASBLEDEN	PO/VO NO.						
	HAWKESBURY ON	WORK LOCATION	SAME					
		ACCEPTANCE STD	ASTM 1417/1418-038	REV./DATE	2005			
PROJECT	F.P.I. ON MACHINED PARTS							
ITEM(S) EXAMINED	30 STUDS							

JOB DESCRIPTION	PROCEDURE NO.	LT-002	REV./DATE	2008	TECHNIQUE NO.	LT-1412	REV./DATE	2008
PART NO.	SEE RESULTS	MATERIAL	STAINLESS STEEL	THICKNESS	VARIOUS			
SCOPE	A WET FLUORESCENT LIQUID PENETRANT INSPECTION WAS CARRIED OUT ON THE 100% EXTERNAL SURFACE.							

TEST DETAILS	
METHOD	<input checked="" type="checkbox"/> FLUORESCENT <input type="checkbox"/> VISIBLE
FAMILY BRAND	MAGNAFLUX
PENETRANT	2467 MINIMUM DWELL TIME 45 MIN.
PENETRANT REMOVER	H2O MINIMUM DRY TIME >10 MIN.
DEVELOPER	1452 MINIMUM DWELL TIME 10 MIN.
DEVELOPER TYPE	<input checked="" type="checkbox"/> NON AQUEOUS <input type="checkbox"/> AQUEOUS <input type="checkbox"/> DRY
	<input checked="" type="checkbox"/> WATER WASH <input type="checkbox"/> SOLVENT REMOVABLE <input type="checkbox"/> POST EMULSIFIED
	BLACK LIGHT S/N 16459 <input type="checkbox"/> OUTPUT > 1000 μ W/cm ² <input type="checkbox"/> AMBIENT < 2 fc
	LIGHTING EQUIP. <input type="checkbox"/> FLASHLIGHT <input type="checkbox"/> TROUBLELIGHT <input type="checkbox"/> OUTPUT > 100 fc @ SURFACE
	OTHER LAB. NO.
	LIGHT METER S/N 1098866 CAL DUE DATE JUL 2012

TEST SURFACE	
SURFACE CONDITION	<input type="checkbox"/> AS GROUND <input type="checkbox"/> AS WELDED <input checked="" type="checkbox"/> MACHINED <input type="checkbox"/> SHOT BLASTED <input checked="" type="checkbox"/> CLEAN BARE METAL
SURFACE TEMPERATURE	<input type="checkbox"/> < -4°C/ 20°F <input type="checkbox"/> -4°C/ 20°F TO 10°C/ 50°F <input checked="" type="checkbox"/> 10°C/ 50°F TO 52°C/ 125°F <input type="checkbox"/> > 52°C/ 125°F

RESULTS- (<input type="checkbox"/> METRIC <input type="checkbox"/> IMPERIAL)
W.O. #
4 - 79308 - STUDS ✓
12 - 80363 - STUDS ✓
6 - 79093 - STUDS ✓
5 - 79300 - STUDS ✓
S12/13/19

Scope of Services

The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care

In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES

CLIENT REPRESENTATIVE	Andrew Sheldon	DTR #	E-63476
TECHNICIAN (SIGNATURE):	Mike Johnston	REPORT REVIEWED BY:	
NAME (PRINT):	1 st TECHNICIAN	NAME	INITIALS
CGSB LEVEL	SNT LEVEL	CGSB LEVEL	SNT LEVEL
CGSB REG. No	CGSB REG. No		

WHITE - CLIENT COPY

CANARY - OFFICE COPY

PINK - TECHNICIAN COPY

GOLD - OFFICE COPY